

Date: Friday, 8/25/2006 11:21:59 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARPAW KIT (19"X16")	
Job Number	: 28343		Part Number	: K10007	
Estimate Number	: 10320		Drawing Number	: D2435 REV E1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 8/25/2006	S.O. No. : N/A	Drawing Revision	: E1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 9/25/2006 Qty: 10 Um: Each	
Previous Run	: 26251				
Written By					
Checked & Approved By					
Comment	: Est Rev:C 04.02.17 Blank size changed KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile: K10007 D206-559 D500-572 D120-638 D058-678 and create labels per PPP K10005 CHG003 (Bag Bluefiles separately)	(1c) Ks 06-09.07
2.0	MUHMWB10	UHMW 1" Black	
		Comment: Qty.: 4.5491 sf(s)/Unit Total : 45.4913 sf(s) blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3 Material: Black UHMW 1" (MUHMWB10) Batch: M161254	3/1 06/09/03 10
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Note: (2) Bearpaw for (1) Kit	J.F. Ankl 06/09/03
		1-Inspect material for defects or damage prior to machining	
		2-Machine as per Folio and Dwg D2435 Identify as D2435	
		3-Deburr	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 06/09/03
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	SA 06.09.04
6.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Pick Packing Kit	
7.0	D2182B	Neoprene Cushion-.750 bl
	Comment: Qty.: 0.4160 f(s)/Unit Total : 4.1600 f(s)	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	4 D2182B050 Rubber Cushion	B28042 ✓
8.0	D2274	Radius Block
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	8 D2274 Radius Block	B27581 ✓
	2 D2435(ref only) Bearpaw	B28343
9.0	D2438	Clamp
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	4 D2438 Clamp	B2561132 ✓ B27080 ²⁸ BB ✓
		<i>B246912</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 8/25/2006 11:22:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 28343

Part Number: K10007

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529

Washer

B07876 ✓

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

M19185 ✓

12.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-17A

Bolt

M19471 ✓

13.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M19185 ✓

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M19085 ✓

DB06/09/12

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/09/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 QS200M44S Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S Clamp ~~1102202~~¹⁶ ~~13~~, 1102039

1 Paperwork package

✓
computer
This Batch #
Boe/09/12

(10)

16.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

(10)

17.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPk10007

Location: Reve

✓
B 06/09/14

(10)

18.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

✓
D 06/09/15

(10)

Job Completion



✓
A 06/09/15

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28343
Description: Bearpaw	Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>JL</u>	Audited by:	<u>J.L</u>	Prototype Approval:	N/A
Date:	06/09/01	Date:	06/09/02	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	03.09.22	New Issue	P/O K10007	KJ/RF	

DART

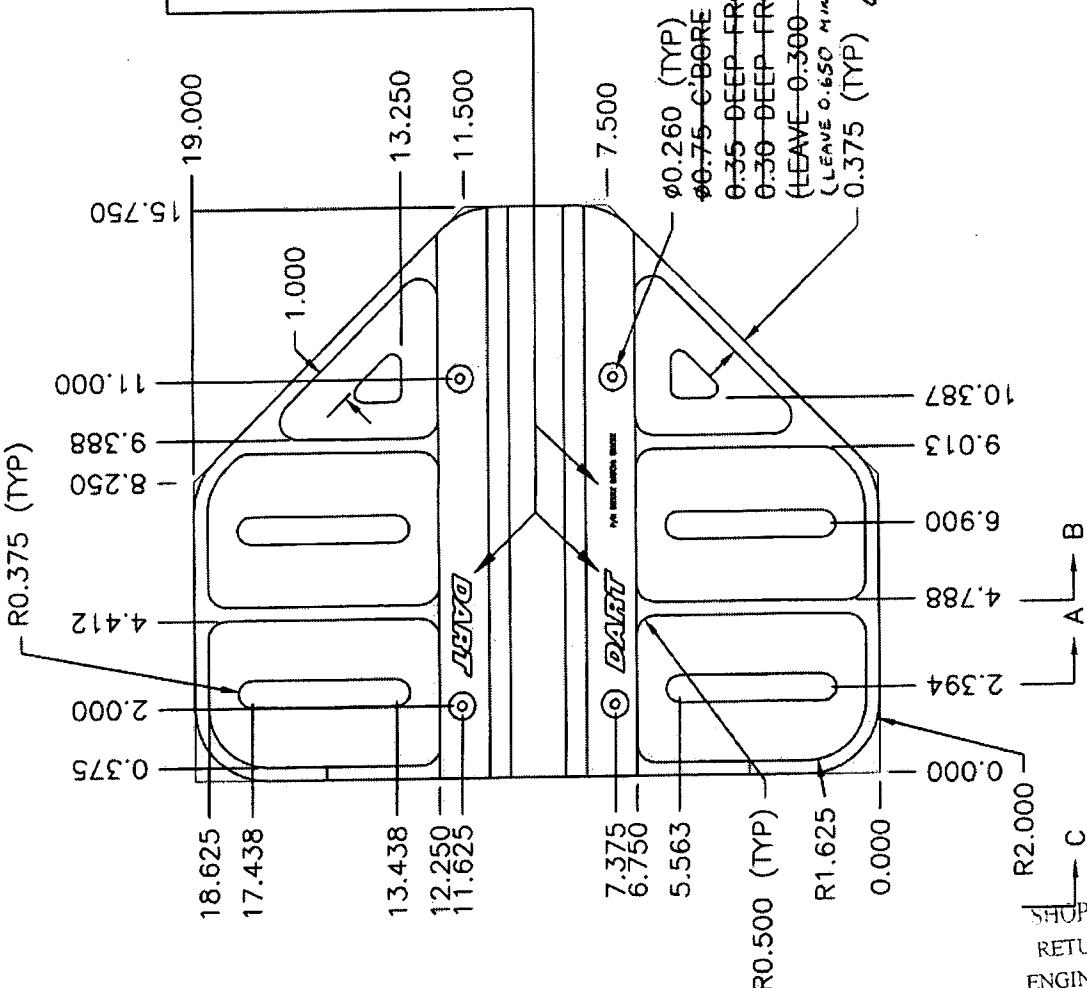
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>PS</i>	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5

RELEASED

19.06.17 KE

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

A → B
C →

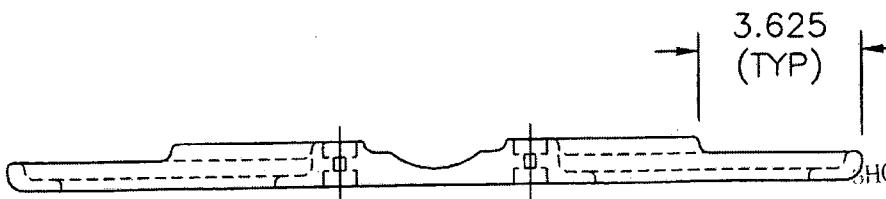
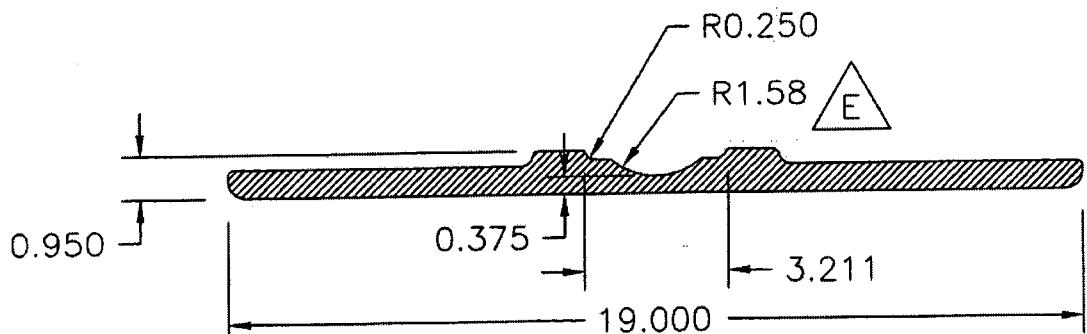
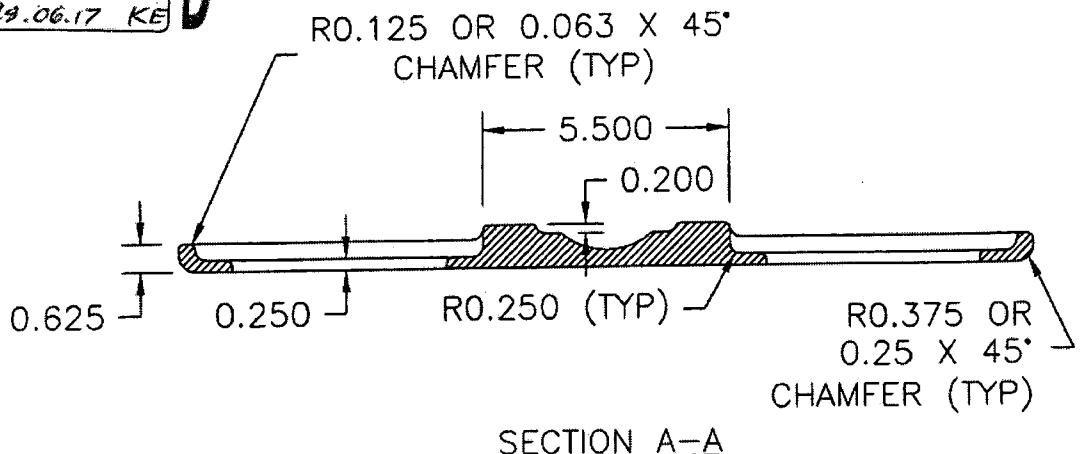


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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *28343*

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA	
CHECKED <i>DW</i>	APPROVED <i>TS</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
49.06.17 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
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WITHOUT NOTICE
WORK ORDER
NO. *28343*